

Work Order ID 58542

May 10, 2010 12:39:12 PM



Page 1

Item ID: D3136-041

Accept



Setup Start



Revision ID:

Item Name: Window Assembly

Stop



Start Date: 10/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: A

Date: 10-5-10

Tooling:

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3136

Rev E

100

0.00



FLOW WATER JET

Waterjet

Memo

E
E
E

0.00

FLOW CNC Waterjet

10-5-13

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-5-13

(6)

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5/10/05/11

(x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58542

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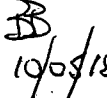


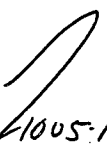
Item ID:	D3136-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Window Assembly				Stop	
Start Date:	10/05/2010	Start Qty:	4.00			
Required Date:	14/05/2010	Req'd Qty:	4.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Thermoform Thermoforming Machine	THERMOFORMING MACHINE Memo 1-Thermoform as per Dwg D3136 and Folio FTA006 □ Dwg Rev. <u>E</u> □ Folio Rev. <u>C</u> □ 2-Engrave Part # and Batch #, and affix labels □ (D3108-9) <u>B34SS4 X10</u>	0.00 0.00							<u>BB</u> <u>10/05/18</u> <u>(X5)</u> <u>(X1) SCRAP</u>
140 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00							<u>BB</u> <u>10/05/18</u> <u>(X5)</u>
150 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							<u>Ph</u> <u>10/05/18</u> <u>X</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3136-041 PAR #: _____ Fault Category: Thermoforming NCR: Yes No DQA: _____ Date: 10/05/18
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: _____ Date: 10/06/01

NCR: <u>58542</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/05/18	130	OVERHEAT PLASTIC WAVES ON EDGES. R.C. process		Scrap + Destroy no Replace qty +1	 10/05/18	 10/05/18		 10/05/18

NOTE: Date & initial all entries

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Item ID: D3136-041

Accept



Setup Start



Revision ID:

Item Name: Window Assembly

Stop



Start Date: 10/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Water sand and buff to remove scratches as required	0.00 0.00							3B 10/05/18 (XS)
170 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Inspect edge and window deformation, wrap in plastic	0.00 0.00							S 10/05/28 (XS)
180 Packaging Packaging	Identify as per dwg & Stock Location: 215 Memo	0.00 0.00							10-5-31 @ SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Setup Start



Revision ID:

Item Name: Window Assembly

Stop



Start Date: 10/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/01

P/10-6-91
6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 58542



Parent Item: D3136-041



Parent Item Name: Window Assembly

Start Date: 10/05/2010

Required Date: 14/05/2010

Comments: IPP B 04.02.04 Reformat KJ/DS
IPP C Thermoform in house 05/07/2007 DL
IPP D Rev E 07.09.28 EC verified by: DD

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
D3108-9		Manufactured	No			100	Each	732.0000	2			
Decal												

Location

Loc Qty

Loc Code

ST036

732

34554

232

46546

500

MACRLICS.125

Purchased

No

170

sf

14.4000

4.25



1/8" Polycast II Sheet

Location

Loc Qty

Loc Code

MAT

14.4

113204

4

113861

10.4

114673

321

114673

~~10~~ X10
10/05/18

1810-5-13

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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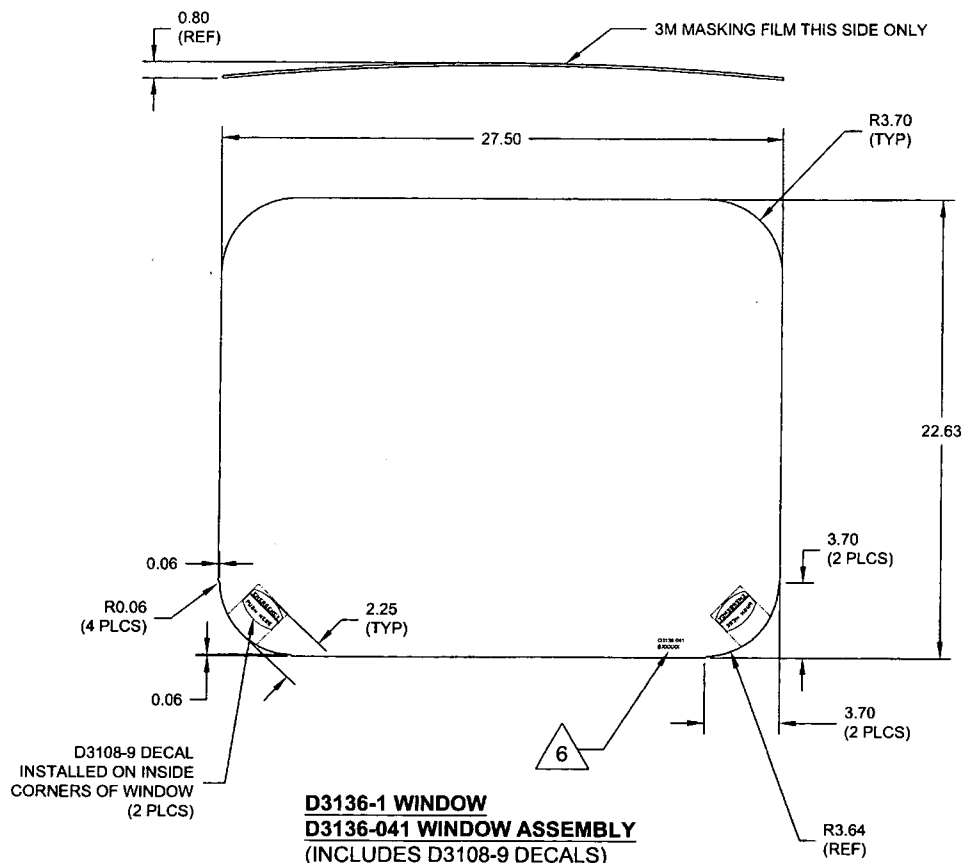
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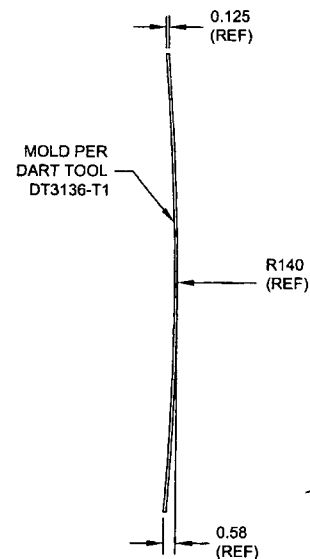
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NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-041" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.98 +/- 0.66 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
b) DRAPE OVER D3136-T1 MOLD & CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS



E	REMOVE TRIM NOTE	DC	07.09.10
D	UPDATED MATERIAL NOTES	RF	05.12.01
C	ADDED FORMING & ENGRAVING SPEC	KJ	04.05.05
B	ADDED D3136-3 AND D3136-043	RF	04.01.21
A	NEW ISSUE	DS	02.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.09.10		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3136	REV. E SHEET 1 OF 2
TITLE WINDOW ASSEMBLY	SCALE 1:6
COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
07.09.22

wlb 58542

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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